

Work Order ID 67530

Monday, March 28, 2011 9:13:51 AM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 3/28/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: PLDate: 11-03-28 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2580-041	Rev.D DEO-D1								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG003

COR for oil CHG007)

Sulos/3 11-5-3

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend I

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

11-3-31

B67530

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67530

Monday, March 28, 2011 9:13:52 AM

Page 2

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Start Date: 3/28/2011 Start Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00



Skidtubes

Memo

0.00

1- Deburr ends and remove bending marks

2- Prepare tube for swaging as per QSI 002

130

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control



11-4-1

1 ~~2~~ BE 11/04/01

W/O:		WORK ORDER CHANGES					
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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

0.00



Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 004

A/R ☐ ☐ Aluminum Rod

m116577

BE 11/04/01

2-Grind welds on step as per Dwg D2580

3-Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension.

WELDED BE 11/04/21
A/R m116577

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Debur

BE 11/04/18

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Debur

BE 11/04/18

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Debur

BE 11/04/21

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

S 11/04/25

⑦

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
170 HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo Re-alodine tube as per QSI 005 section 4.1.2. I do not acid etch and leave fwd cap out of solution.	0.00 0.00							
180 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M 116 964. Memo START TIME: 1:10 OVEN TEMPERATURE: 350° FINISH TIME: 1:40.	0.00 0.00							

FD

1 BR 11-4-26.

1 BR 11-4-26.

W/O:		WORK ORDER CHANGES					
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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00				1	0	1104127	
Quality Control									

~~RECEIVED~~
3

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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200

0.00



HandFinish

Hand Finishing

Memo

0.00

✓ 1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R ☐ ☐ ☐ Sikaflex-291 ☐ M116198
Sikaflex expire date: 12/01

✓ 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

✓ 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R ☐ ☐ ☐ Sikaflex-291 ☐ M116198
Sikaflex expire date: 12/01

✓ 5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: M117315

1 0 11 4/04/27

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Picklist Print

Monday, March 28, 2011 9:13:58 AM

Page 1

Work Order ID: 67530

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 3/28/2011

Required Date: 4/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30
KJ IPP Rev P 10.02.19
per PAR09-043 EC verified by:DD
IPP Rev. O 06.02.28 Added paperwork EC
IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q
10.12.01 as per chg003 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2579
Spacer

Manufactured

No

140

Each

303.0000

20

20

Location

Loc Qty

Loc Code

LG002

303

66929

106

67129

196

67308

1

D2580-1

Manufactured

No

110

Each

0.0000

1

1

205 Skidtube bent detail

D2576-3

Manufactured

No

140

Each

17.0000

1

1

Step (maching detail)

Location

Loc Qty

Loc Code

LG

17

52215

17

BE 11/04/21
B 624001 v20

Ⓟ DP 11-3-31

BE 11/04/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Monday, March 28, 2011 9:13:58 AM

Work Order ID: 67530

Parent Item: D205-634-041




Parent Item Name: Replacement Skidtube

Start Date: 3/28/2011

Required Date: 4/12/2011



Start Qty: 1.00

Required Qty: 1.00

D2855 Manufactured No 200 Each 78.0000 1 1
  
 Cap



Location	Loc Qty	Loc Code
FP007	78	
53791	41	
65519	2	
65569	35	

Y1 1104127



AN3-5A Purchased No 200 Each 446.0000 2 2
 
 Bolt

Location	Loc Qty	Loc Code
FP-B	5	
115016	5	
ST350	441	
115371	300	
116632	141	

Y2 1104127

AN960JD10L NAS1149D0332J Purchased No 200 Each 0.0000 2 2
 
 Washer

(x2) Y1 1104127

ALS7-1032-130 Purchased No 200 Each 755.0000 50 50
 
 Insert

Location	Loc Qty	Loc Code
ST282	755	
116800	755	

Y50 1117331

W/O:		WORK ORDER CHANGES					
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Monday, March 28, 2011 9:13:59 AM

Work Order ID: 67530

Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 3/28/2011

Required Date: 4/12/2011



Start Qty: 1.00



Required Qty: 1.00



AN3C4A	Purchased	No	200	Each	122.0000	50	50
							HL 11/04/27
BOLT							

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			ST350	122			
			116924	122			x50
AN960C10L	Purchased	No		200	Each	0.0000	50
NAS1149C0332							50
R							

							(x50) HL 11/04/27
---	--	--	--	--	--	---	-------------------

washer							
D3566-13	Manufactured	No		200	Each	35.0000	1
							HL 11/04/27
Gasket							

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			FP014	35			
			66550	35			x1
D3566-5	Manufactured	No		200	Each	11.0000	1
							HL 11/04/27
Gasket							

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			FP015	11			
			66552	11			x1
D3566-1	Manufactured	No		200	Each	8.0000	2
							HL 11/04/27
Gasket							

			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>		
			FP011	8			
			67496	8			x2

W/O:		WORK ORDER CHANGES					
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Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 3/28/2011



Required Date: 4/12/2011

Start Qty: 1.00



Required Qty: 1.00

D3564-11	Manufactured	No	200	Each	11.0000	1	1
							<u>xl</u> 11/04/27
Wearshoe							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP019	11	
66154	11	

D3564-13	Manufactured	No	200	Each	46.0000	1	1
							<u>xl</u> 11/04/27
Wearshoe							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP017	46	
66136	19	
66549	9	
66805	18	

D3564-9	Manufactured	No	200	Each	8.0000	1	1
							<u>xl</u> 11/04/27
Wearshoe							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP019	8	
66153	8	B67596

D3564-5	Manufactured	No	200	Each	18.0000	1	1
							<u>xl</u> 11/04/27
Wearshoe							

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	2	
34806	2	
FP019	16	
66551	16	

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Start Date: 3/28/2011

Required Date: 4/12/2011

Start Qty: 1.00

Required Qty: 1.00

D2594-3 Manufactured No

200 Each

492.0000 16 16



O-Ring, 205 Skidtube



Handwritten: 16 3/28/11

Location

Loc Qty

Loc Code

FP-A

492

65518

492

Handwritten: 16

D2594-1 Manufactured No

200 Each

519.0000 16 16



Plug, 205 Skidtube



Handwritten: 16 3/28/11

Location

Loc Qty

Loc Code

FP-A

519

42807

28

66122

244

66932

240

67441

7

Handwritten: 16

W/O:		WORK ORDER CHANGES					
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DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07.06.28 *[Signature]***DEO ATTACHED**

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47530
P/11-03-28

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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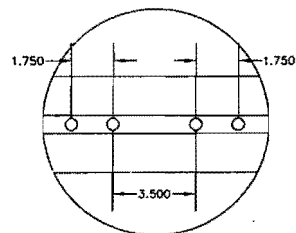
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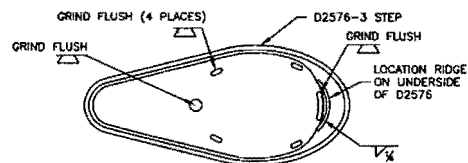
NOTE: Date & initial all entries

WLO 67530

DETAIL A
SCALE 5:24



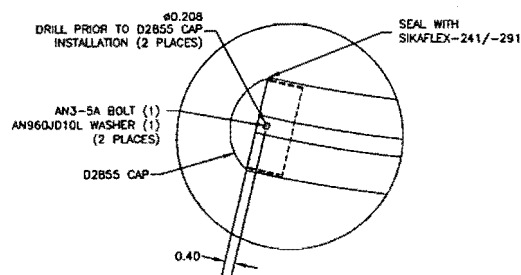
DETAIL B
SCALE 5:24



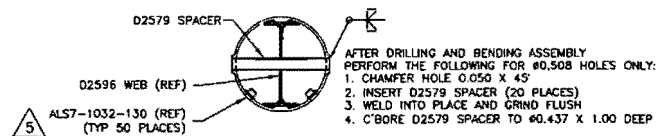
RELEASED
07.06.28

DEO ATTACHED

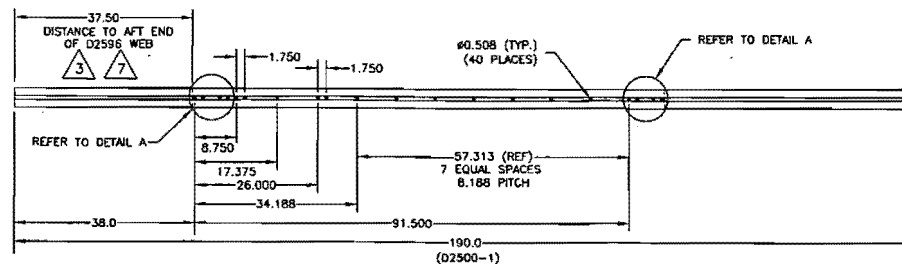
DETAIL C
SCALE 5:24



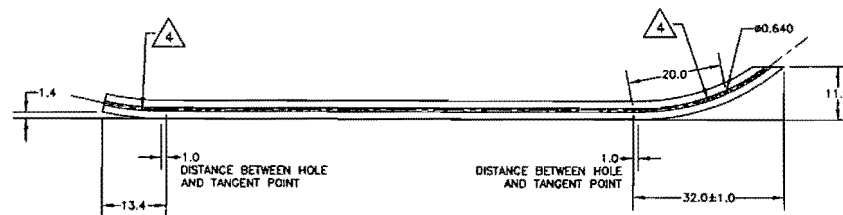
SECTION D-D
SCALE 5:24



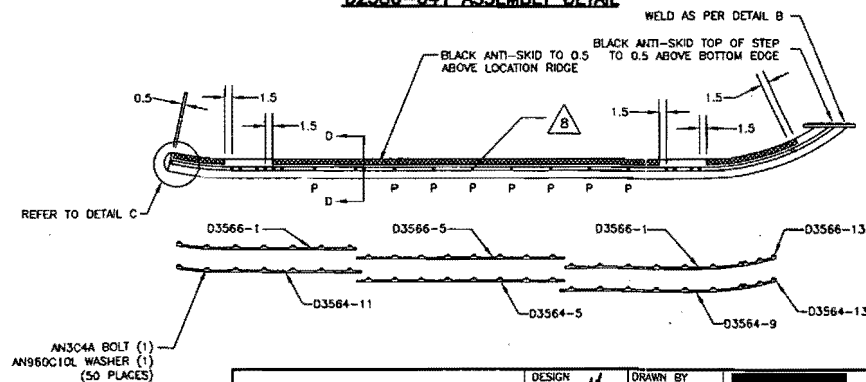
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



D2580-041 NOTES

- 1) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD.
CHECKED	APPROVED	DRAWING NO.	HARRISBURG, ONTARIO, CANADA
DATE		D2580	REV. D
		TITLE	SHEET 2 OF 3
		205 SKIDTUBE ASSEMBLY	SCALE
			1:24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

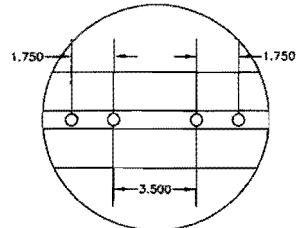
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

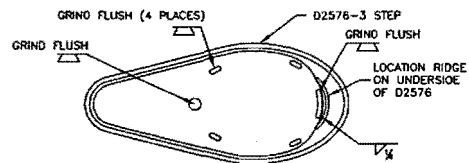
NOTE: Date & initial all entries

W/10 17530

DETAIL E
SCALE 5:24



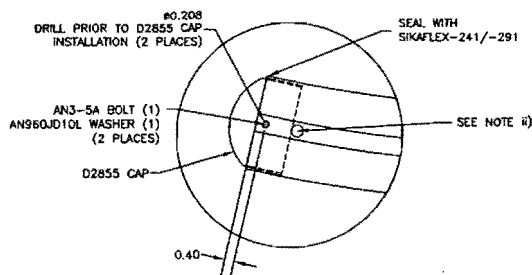
DETAIL F
SCALE 5:24



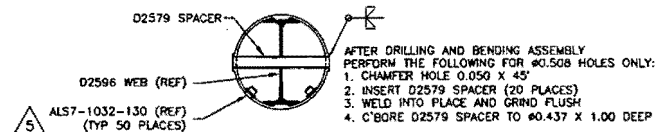
RELEASED
07-16-78

DEO ATTACHED

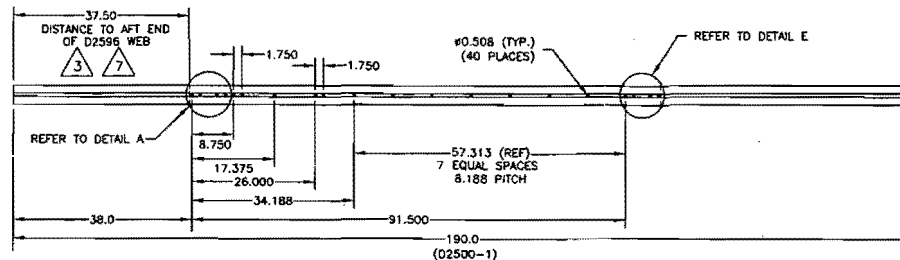
DETAIL G
SCALE 5:24



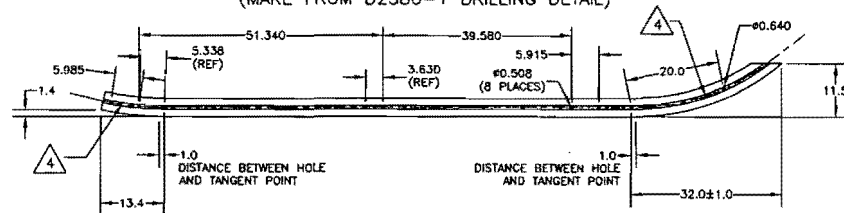
SECTION H-H
SCALE 5:24



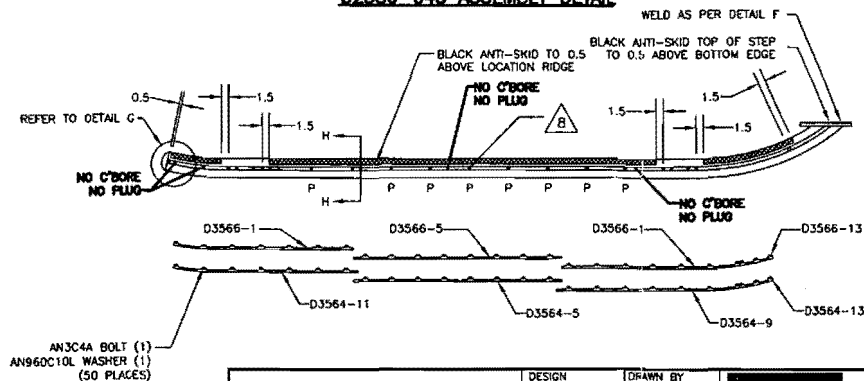
D2580-1 DRILLING DETAIL



D2580-5 BENDING AND CUTTING DETAIL
(MAKE FROM D2580-1 DRILLING DETAIL)



D2580-045 ASSEMBLY DETAIL



D2580-045 NOTES

- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3 BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- ii) IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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DESIGN <i>RH</i>	DRAWN BY <i>RH</i>	DART DART AEROSPACE LTD. WILMINGTON, ONTARIO, CANADA	REV. 0
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D2580	SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D2580	TITLE 205 SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2580-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>L</i>	MFG. APPR. <i>R</i>	APPROVED <i>MP</i>		DE APPR. <i>MP</i>		
DATE 10.09.22	DATE 10.11.04	DATE 10.11.04	DATE 10/11/04		DATE 10.11.04		

PURPOSE:

CHANGE ALL WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

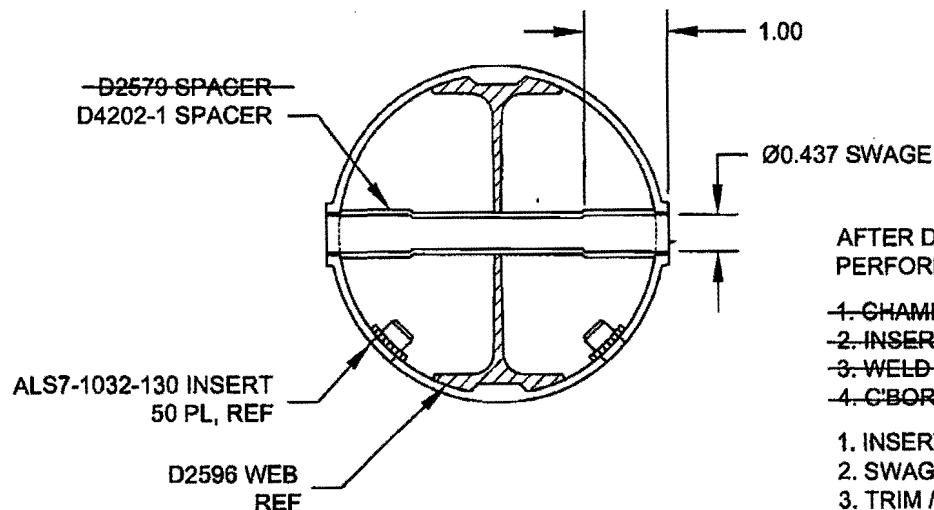
WAS

QTY -041	QTY -045	PART NUMBER	DESCRIPTION
20	24	D2579	CROSS BOLT SPACER

IS

20	24	D4202-1	SPACER
----	----	---------	--------

SECTION D-D & SECTION H-H ARE AMENDED AS FOLLOWS:



SECTION D-D
NOT TO SCALE

SECTION H-H
NOT TO SCALE

RELEASED
2010-11-18
MP

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2570 SPACER (20 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C-BORE D2570 SPACER TO Ø0.437 X 1.00 DEEP

1. INSERT D4202-1 SPACER, 20 PL (-041) OR 24 PL (-045)
2. SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Linda Lacelle

From: dshepherd@dartaero.com
Sent: April 18, 2011 11:36 AM
To: Linda Lacelle; Mike Petsche
Cc: Bill Beckett; 'Chris Provencal'; 'Eric Charbonneau'
Subject: Re: Alum. Solution Anneal - swaging

Makes sense to me ... We don't want to get caught short ... Make sure that if we do this, they are identified with the old CHG number.

David

Sent from my BlackBerry device on the Rogers Wireless Network

From: "Linda Lacelle" <llacelle@dartaero.com>
Date: Mon, 18 Apr 2011 11:21:10 -0400
To: 'Mike Petsche' <mpetsche@dartaero.com>; <dshepherd@dartaero.com>
Cc: 'Bill Beckett' <bbeckett@dartaero.com>; 'Chris Provencal' <cprovencal@dartaero.com>; 'Eric Charbonneau' <echarbonneau@dartaero.com>
Subject: RE: Alum. Solution Anneal - swaging

I am ready to weld some up, I don't want to get into trouble with L/T's on these, any objections??
LL

From: Mike Petsche [mailto:mpetsche@dartaero.com]
Sent: April 18, 2011 10:42 AM
To: 'Linda Lacelle'; dshepherd@dartaero.com
Cc: 'Bill Beckett'; 'Chris Provencal'; 'Eric Charbonneau'
Subject: RE: Alum. Solution Anneal - swaging

Well I'm not sure what to say.

CHG 007

D2579

It is my understanding that the swaging will still make sense even with the extra hoops we need to jump through.

If there is still uncertainty on the delivery of the material, we CAN still weld them if we need to.

And while this might be less than "world class", couldn't we take some of our tubing that we have in stock and zap it with the welder to knock down the temper a little? Ground clamp on one end, torch on the other.....BZZZZZZT.

(I'm only sort of joking....because I bet it would work)

From: Linda Lacelle [mailto:llacelle@dartaero.com]
Sent: April 18, 2011 9:44 AM
To: dshepherd@dartaero.com; 'Mike Petsche'
Cc: Bill Beckett; Chris Provencal; Eric Charbonneau
Subject: RE: Alum. Solution Anneal - swaging
Importance: High

So any thoughts about going fwd for now with 205's? We are down to 6, and I don't want to run out as we have orders for these for early May.

LL

From: Linda Lacelle [mailto:llacelle@dartaero.com]

Sent: April 12, 2011 8:11 AM

To: dshepherd@dartaero.com; 'Mike Petsche' (mpetsche@dartaero.com)

Cc: Bill Beckett (bbeckett@dartaero.com); Chris Provencal (cprovencal@dartaero.com); Eric Charbonneau (echarbonneau@dartaero.com)

Subject: FW: Alum. Solution Anneal - swaging

So if we send them 400 pcs of the 6061T6 tube, they can temper it to T4 for a cost of 1850.00...

LL

From: John Spencer [mailto:johns@metcor.biz]

Sent: April 12, 2011 8:04 AM

To: llacelle@dartaero.com

Subject: Alum. Solution Anneal

Linda,

Metcor could process the tubes within a few days after receiving.

Price for the lot is \$1850 including conductivity test.

Would prefer 8 inch cut to length, if not we could manage 4 " lengths .

Please let me know and contact me on my cell.

Regards,

John Spencer

Metcor Inc.

Nadcap Certified

johns@metcor.biz

514-386-1620

NO. 249

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 67531
Part number: D205 634 041
Description: 205
Welding Process: Tig ☒ Mig ☐
Base material: Aluminum
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Pat Farney Date of Test Coupon 11-04-25

Welder Barclay Elliott Date of Test Coupon 11-04-25

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

